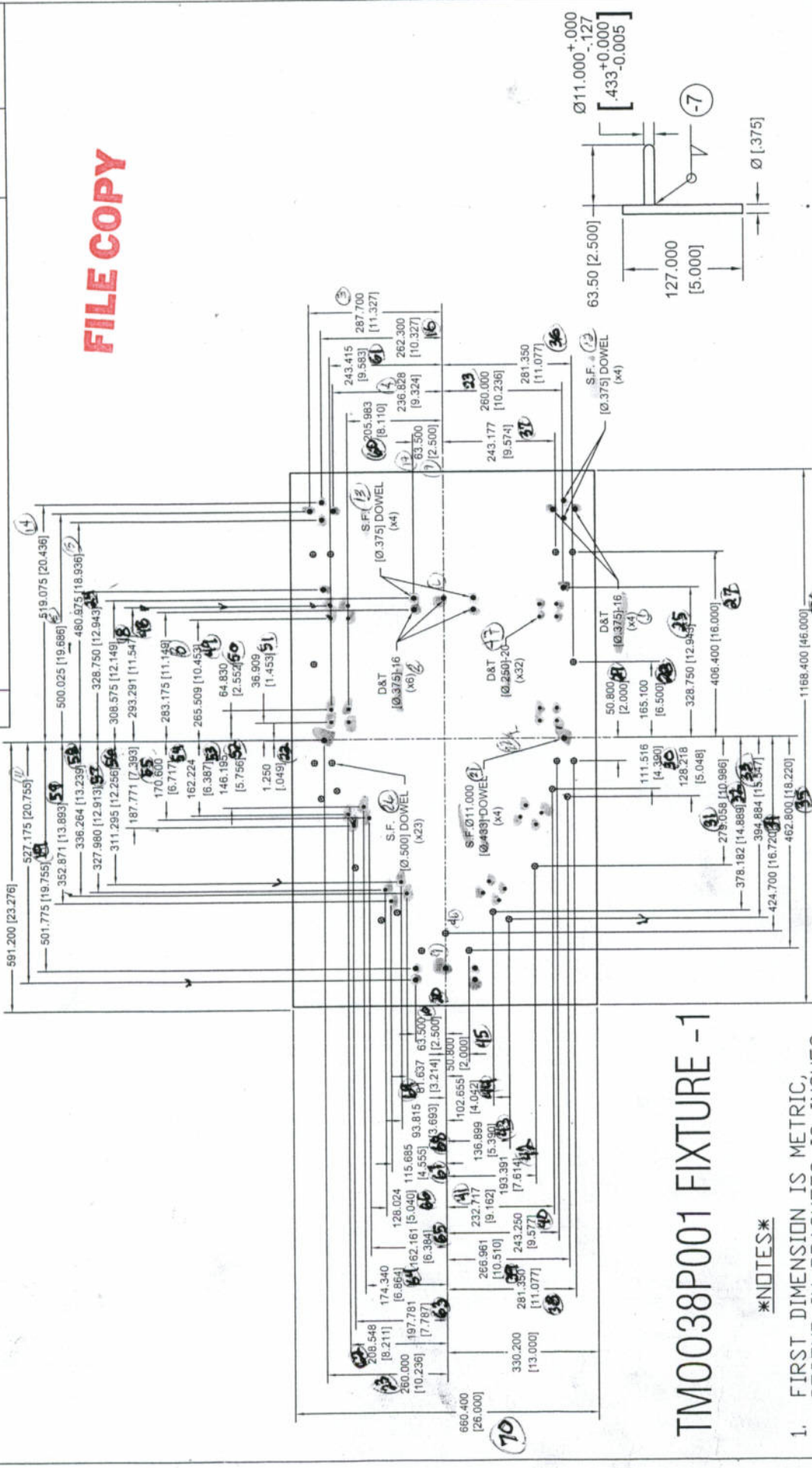


REVISIONS		
REV	DESCRIPTION	DATE

FILE COPY



# TM0038P001 FIXTURE - 1

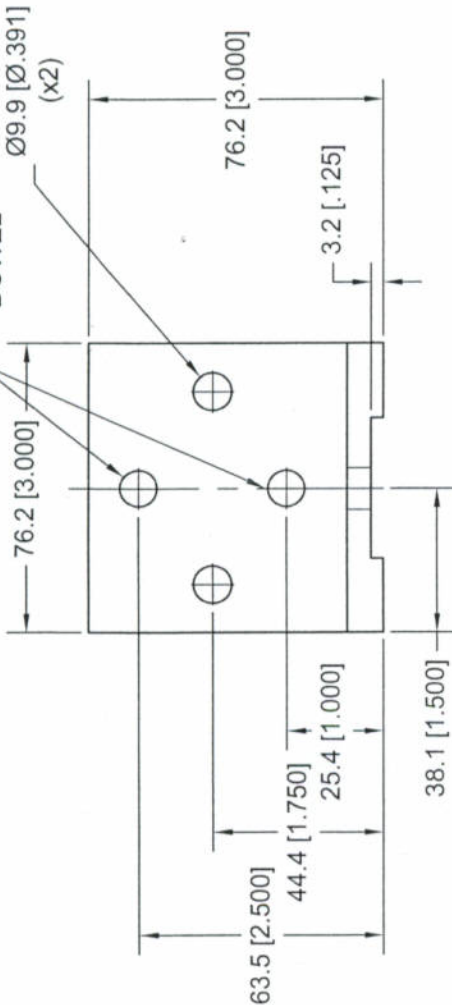
## \*NOTES\*

1. FIRST DIMENSION IS METRIC, SECOND IN BRACKETS IS INCHES.
2. TOP HALF SYMMETRICAL W/BOTTOM.
3. RELATE HOLES TO PATTERNS

DRAWN BY: PERRITT		RED BARN MACHINE	
APPROVED		CHASSIS FIXTURE	
HEAT TREAT		TITLE	
FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:		FRACTIONS ± 1/32	
DECIMALS		XXX ± .005	
XXX ± .01		ANGLES ± 5°	
X		UNLESS OTHERWISE SPECIFIED	
UNLESS OTHERWISE SPECIFIED		1. BREAK ALL SHARP EDGES	
.015 x 45° PR .015 R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL		VOIR NOTA PL.0	
PART #		DESCRIPTION	
QTY			
-FIX-1		6061 PLATE 3/4" x 26 x 46 LONG	
-FIX-3A		1018 Ø1/2" x 2-1/2" RND STOCK	
-FIX-3B		1018 Ø3/8" x 5 RND STOCK	
DWG NO. TM0038P001-FIX-1		REV	
SCALE NTS		DATE 10-5-06	
SHEET 1 of 4			

FILE COPY

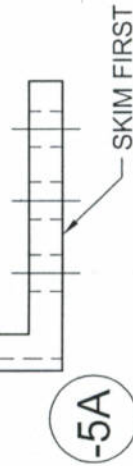
P.F. [Ø.375"]  
DOWEL  
Ø9.9 [Ø.391]  
(x2)



Ø11.0<sup>+0.0</sup><sub>-.1</sub> [Ø.433<sup>+0.000</sup><sub>-0.005</sub>]



-5B



-5A

\*NOTES\*

1. FIRST DIMENSION IS METRIC,  
SECOND IN BRACKETS IS INCHES.
2. PRESS -5B INTO -5A

DRAWN BY: PERRITT		REV		DATE		APPROVED	
APPROVED							
HEAT							
TREAT							
FINISH							
SPEC							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES							
TOLERANCES ON:							
DECIMALS							
XXX ± .005							
XX ± .01							
X ± .1							
ANGLES ± 5°							
UNLESS OTHERWISE SPECIFIED							
1. BREAK ALL SHARP EDGES							
2. DIMENSIONAL LIMITS APPLY AFTER PLATING							
USED ON MODEL							
VOIR NOTA PL.0							
DESCRIPTION							
1018 ANGLE 3 x 3 x 3/8 x 3 LONG							
1018 Ø11mm [Ø.433] x 1/2" LONG PINS							
PART #	QTY						
-FIX-5A	2						
-FIX-5B	2						

DRAWN BY: PERRITT		REV		DATE		APPROVED	
APPROVED							
HEAT							
TREAT							
FINISH							
SPEC							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES							
TOLERANCES ON:							
DECIMALS							
XXX ± .005							
XX ± .01							
X ± .1							
ANGLES ± 5°							
UNLESS OTHERWISE SPECIFIED							
1. BREAK ALL SHARP EDGES							
2. DIMENSIONAL LIMITS APPLY AFTER PLATING							
USED ON MODEL							
VOIR NOTA PL.0							
DESCRIPTION							
1018 ANGLE 3 x 3 x 3/8 x 3 LONG							
1018 Ø11mm [Ø.433] x 1/2" LONG PINS							
PART #	QTY						
-FIX-5A	2						
-FIX-5B	2						

DRAWN BY: PERRITT		REV		DATE		APPROVED	
APPROVED							
HEAT							
TREAT							
FINISH							
SPEC							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES							
TOLERANCES ON:							
DECIMALS							
XXX ± .005							
XX ± .01							
X ± .1							
ANGLES ± 5°							
UNLESS OTHERWISE SPECIFIED							
1. BREAK ALL SHARP EDGES							
2. DIMENSIONAL LIMITS APPLY AFTER PLATING							
USED ON MODEL							
VOIR NOTA PL.0							
DESCRIPTION							
1018 ANGLE 3 x 3 x 3/8 x 3 LONG							
1018 Ø11mm [Ø.433] x 1/2" LONG PINS							
PART #	QTY						
-FIX-5A	2						
-FIX-5B	2						

DRAWN BY: PERRITT		REV		DATE		APPROVED	
APPROVED							
HEAT							
TREAT							
FINISH							
SPEC							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES							
TOLERANCES ON:							
DECIMALS							
XXX ± .005							
XX ± .01							
X ± .1							
ANGLES ± 5°							
UNLESS OTHERWISE SPECIFIED							
1. BREAK ALL SHARP EDGES							
2. DIMENSIONAL LIMITS APPLY AFTER PLATING							
USED ON MODEL							
VOIR NOTA PL.0							
DESCRIPTION							
1018 ANGLE 3 x 3 x 3/8 x 3 LONG							
1018 Ø11mm [Ø.433] x 1/2" LONG PINS							
PART #	QTY						
-FIX-5A	2						
-FIX-5B	2						

 RED BARN MACHINE	
TITLE	
CHASSIS FIXTURE	
DWG NO.	REV
TM0038P001-FIX-5	
SCALE	DATE
NTS	10-5-06
SHEET 2 of 4	

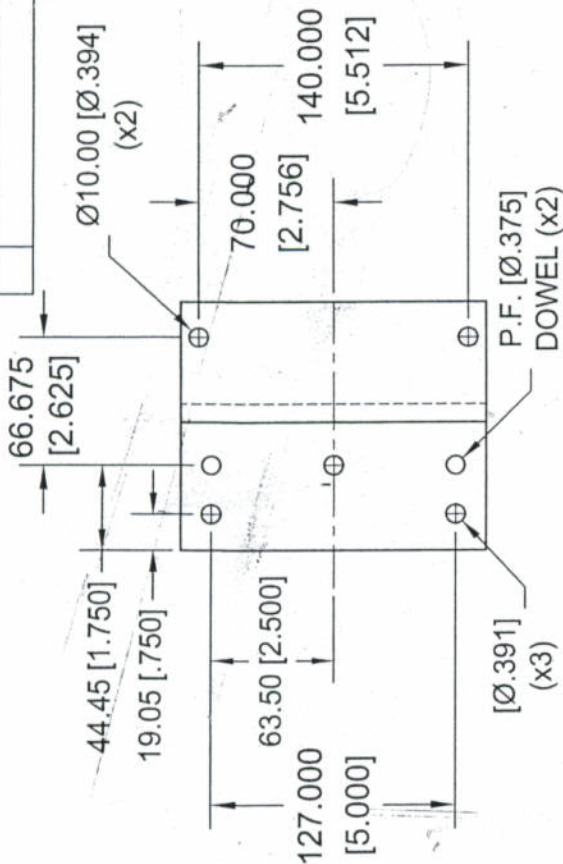


REVISIONS		
REV	DESCRIPTION	DATE

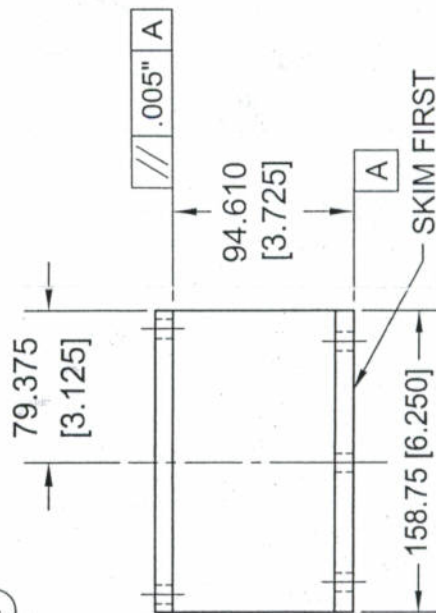
APPROVED

DATE

FILE COPY



(-7)



# \*NOTES\*

- FIRST DIMENSION IS METRIC, SECOND IN BRACKETS IS INCHES.
- MACHINE 7B TO SIZE BEFORE WELDING.
- WELD PLATE BEFORE MACHINING.

DRAWN BY: PERRITT		REVISIONS	
APPROVED		DATE	
HEAT TREAT		DATE	
FINISH SPEC		DATE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DATE	
TOLERANCES ON:		DATE	
DECIMALS		DATE	
XXX ± .005		DATE	
XX ± .01		DATE	
X ± .01		DATE	
FRACTIONS ± 1/32		DATE	
ANGLES ± .5°		DATE	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		DATE	
USED ON MODEL		DATE	
VOIR NOTA PL.0		DATE	
1018 FLAT BAR 3 x 3/8 x 6-1/4 LONG		DATE	
1018 FLAT BAR 3-1/2 x 3/8 x 6-1/4 LONG		DATE	
1018 FLAT BAR 2-1/2 x 3/8 x 6-1/4 LONG		DATE	
Ø3/8 x 3/4 DOWEL PINS		DATE	
QTY		DATE	
PART #		DATE	
-FIX-7A		DATE	
-FIX-7B		DATE	
-FIX-7C		DATE	
-FIX-7D		DATE	

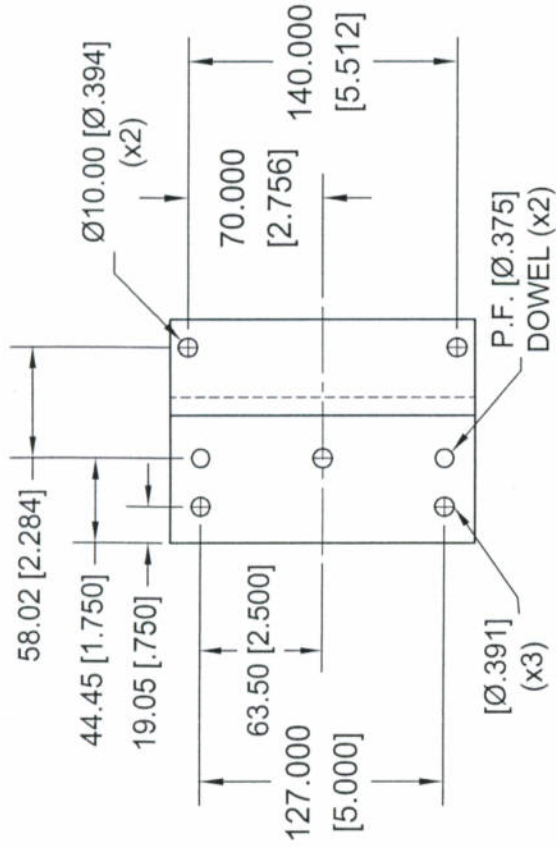
RED BARN MACHINE

CHASSIS FIXTURE

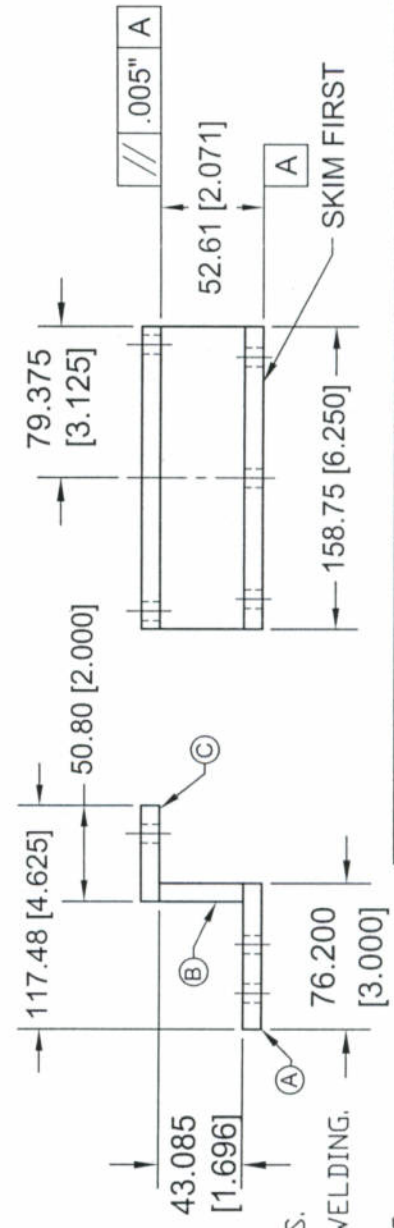
DWG NO. TM0038P001-FIX-7 REV

SCALE NTS DATE 10-5-06 SHEET 3 of 4

REVISIONS		
REV	DESCRIPTION	DATE



**FILE COPY**

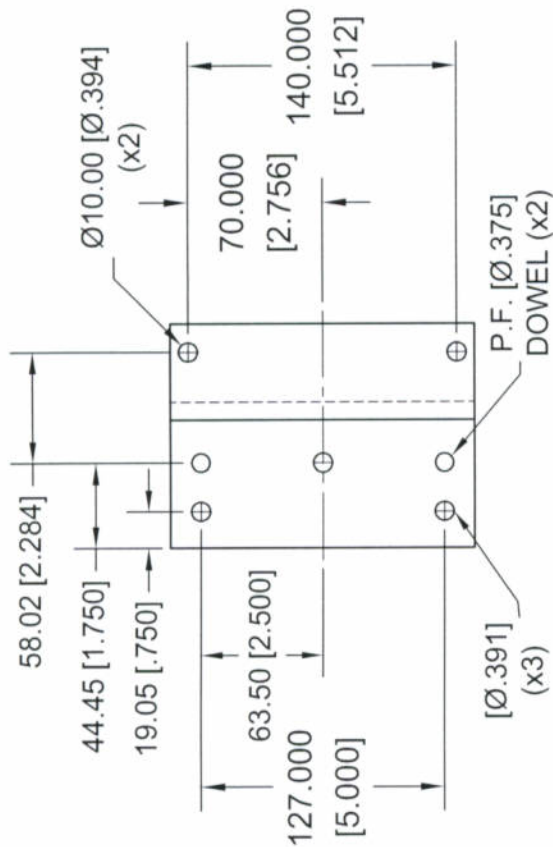


**\*NOTES\***

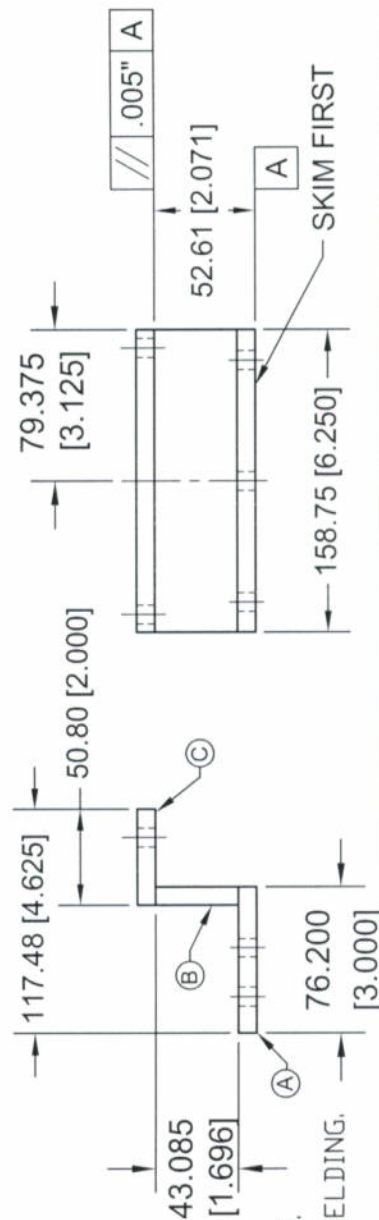
1. FIRST DIMENSION IS METRIC, SECOND IN BRACKETS IS INCHES.
2. MACHINE 7B TO SIZE BEFORE WELDING.
3. WELD PLATE BEFORE MACHINING.

DRAWN BY: PERRITT		REVISIONS	
APPROVED		DATE	
HEAT TREAT		APPROVED	
FINISH SPEC		DATE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS		TITLE	
TOLERANCES ON:		CHASSIS FIXTURE	
XXX ± .005		DWG NO. TM0038P001-FIX-9	
XX ± .01		REV	
X ± .1		SCALE	
FRACTIONS ± 1/32		DATE	
ANGLES ± 5°		SHEET	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 X 45° PR .015 R		4 of 4	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		10-5-06	
USED ON MODEL		NTS	
VOIR NOTA PL.0		10-5-06	
DESCRIPTION		10-5-06	
PART #	QTY	10-5-06	
-FIX-9A	1	10-5-06	
-FIX-9B	1	10-5-06	
-FIX-9C	1	10-5-06	
-FIX-9D	2	10-5-06	
1018 FLAT BAR 3 x 3/8 x 6-1/4 LONG		10-5-06	
1018 FLAT BAR 2 x 3/8 x 6-1/4 LONG		10-5-06	
1018 FLAT BAR 2 x 3/8 x 6-1/4 LONG		10-5-06	
Ø3/8 x 3/4 DOWEL PINS		10-5-06	

REVISIONS		
REV	DESCRIPTION	DATE



FILE COPY



# \*NOTES\*

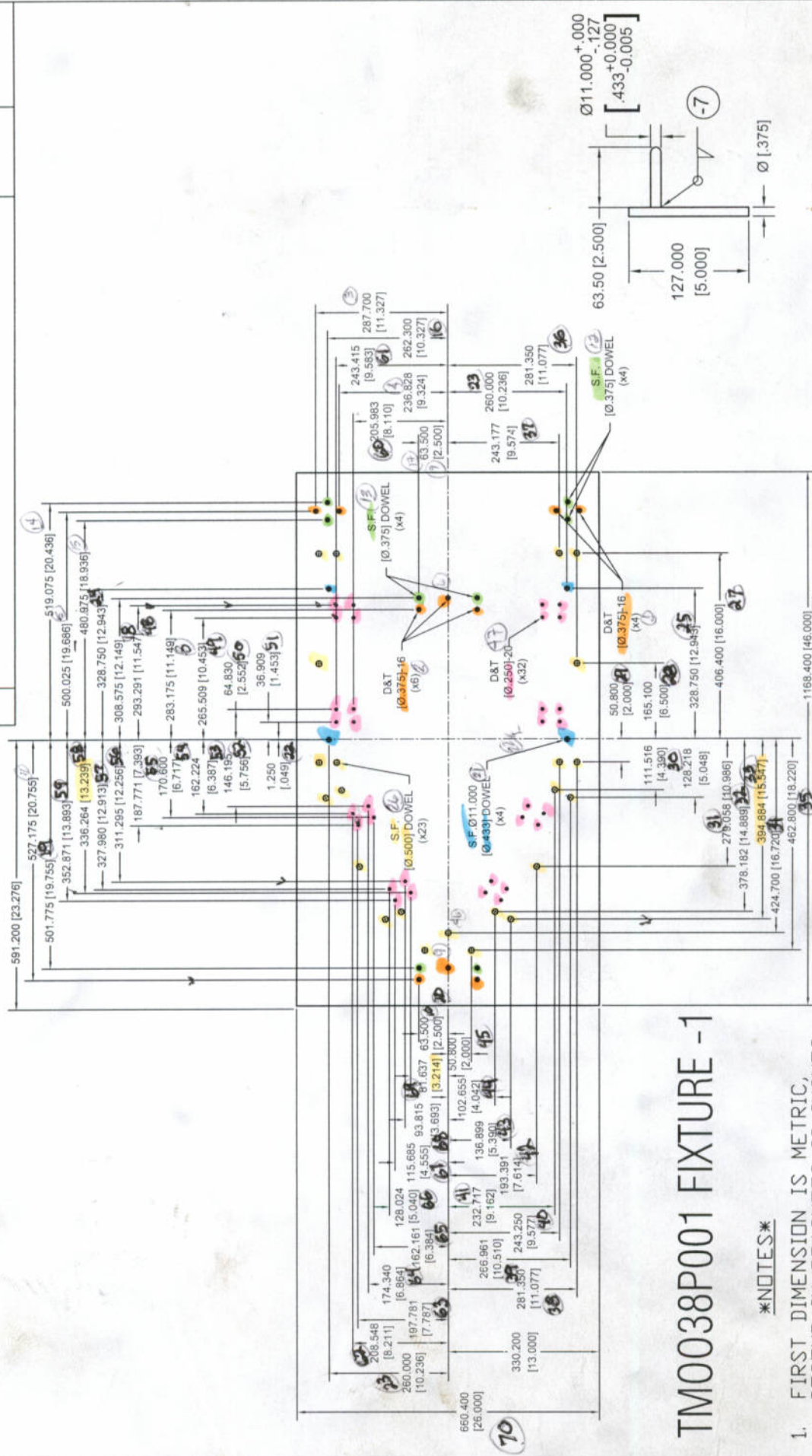
1. FIRST DIMENSION IS METRIC, SECOND IN BRACKETS IS INCHES.
2. MACHINE 7B TO SIZE BEFORE WELDING.
3. WELD PLATE BEFORE MACHINING.

DRAWN BY: PERRITT		REDA BARN MACHINE	
APPROVED		TITLE	
HEAT TREAT		CHASSIS FIXTURE	
FINISH SPEC		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
		TOLERANCES ON:	
		XXX ± .005	
		XX ± .01	
		X ± .1	
		FRACTIONS ± 1/32	
		ANGLES ± 5°	
		UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R	
		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
		DWG NO. TM0038P001-FIX-9	REV
		SCALE NTS	DATE 10-5-06
		SHEET 4	OF 4

PART #	QTY	DESCRIPTION
-FIX-9A	1	1018 FLAT BAR 3 x 3/8 x 6-1/4 LONG
-FIX-9B	1	1018 FLAT BAR 2 x 3/8 x 6-1/4 LONG
-FIX-9C	1	1018 FLAT BAR 2 x 3/8 x 6-1/4 LONG
-FIX-9D	2	Ø3/8 x 3/4 DOWEL PINS



REVISIONS		
REV	DESCRIPTION	DATE



## TM0038P001 FIXTURE - 1

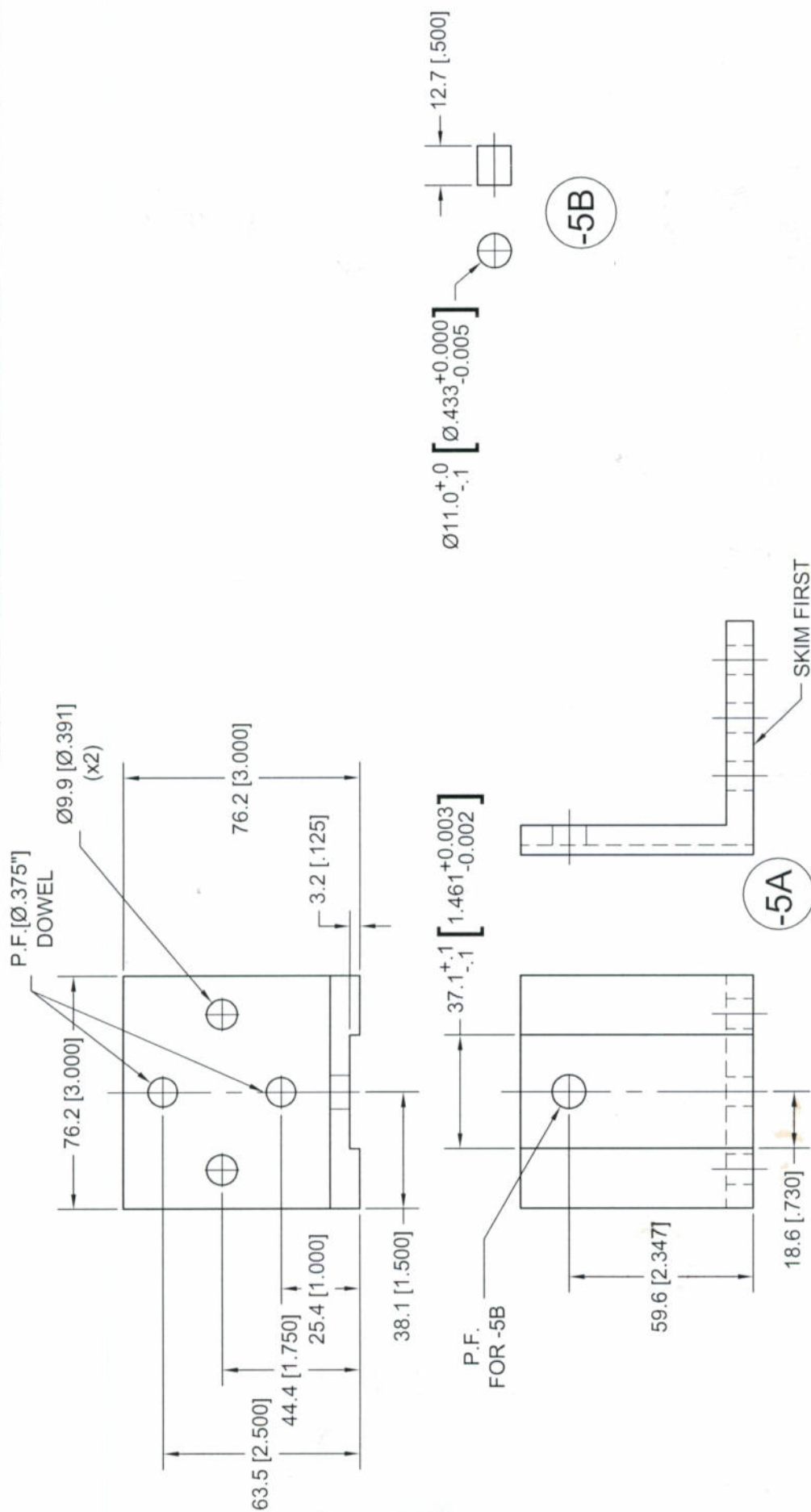
### \*NOTES\*

1. FIRST DIMENSION IS METRIC, SECOND IN BRACKETS IS INCHES.
2. TOP HALF SYMMETRICAL W/BOTTOM.
3. RELATE HOLES TO PATTERNS

DRAWN BY: PERRITT		RED BARN MACHINE	
APPROVED		TITLE	
HEAT TREAT		CHASSIS FIXTURE	
FINISH SPEC		DWG NO. TM0038P001-FIX-1	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		SCALE NTS	
TOLERANCES ON:		DATE 10-5-06	
DECIMALS .XXX ± .005		SHEET 1 of 4	
FRACTIONS ± 1/32		REV	
ANGLES ± 5°		TM0038P001-FIX-1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			

PART #	QTY	DESCRIPTION
-FIX-1	1	6061 PLATE 3/4" x 26 x 46 LONG
-FIX-3A	4	1018 Ø1/2" x 2-1/2" RND STOCK
-FIX-3B	4	1018 Ø3/8" x 5 RND STOCK

REVISIONS		
REV	DESCRIPTION	DATE



# \*NOTES\*

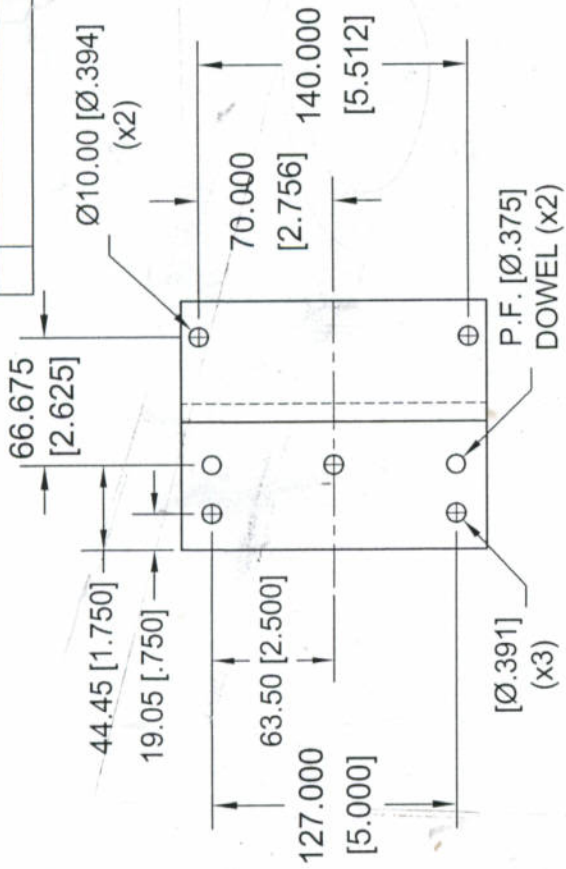
1. FIRST DIMENSION IS METRIC, SECOND IN BRACKETS IS INCHES.
2. PRESS -5B INTO -5A

DRAWN BY: PERRITT		REV	
APPROVED		DATE	
HEAT		APPROVED	
TREAT			
FINISH			
SPEC			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TITLE	
TOLERANCES ON:		RED BARN MACHINE	
DECIMALS		CHASSIS FIXTURE	
XXX ± .005		DWG NO. TM0038P001-FIX-5	
XX ± .01		SCALE	
X ± .1		NTS	
FRACTIONS ± 1/32		DATE	
ANGLES ± 5°		10-5-06	
UNLESS OTHERWISE SPECIFIED		SHEET	
1. BREAK ALL SHARP EDGES		2 of 4	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			

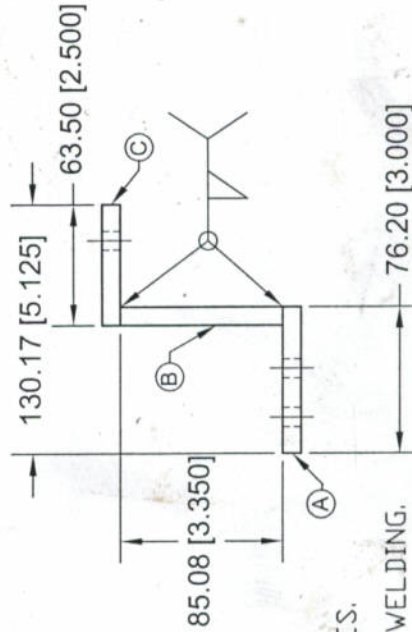
PART #	QTY	DESCRIPTION
-FIX-5A	2	1018 ANGLE 3 x 3 x 3/8 x 3 LONG
-FIX-5B	2	1018 Ø11mm[Ø.433] x 1/2" LONG PINS



REVISIONS		
REV	DESCRIPTION	DATE



(-7)



**\*NOTES\***

1. FIRST DIMENSION IS METRIC, SECOND IN BRACKETS IS INCHES.
2. MACHINE 7B TO SIZE BEFORE WELDING.
3. WELD PLATE BEFORE MACHINING.

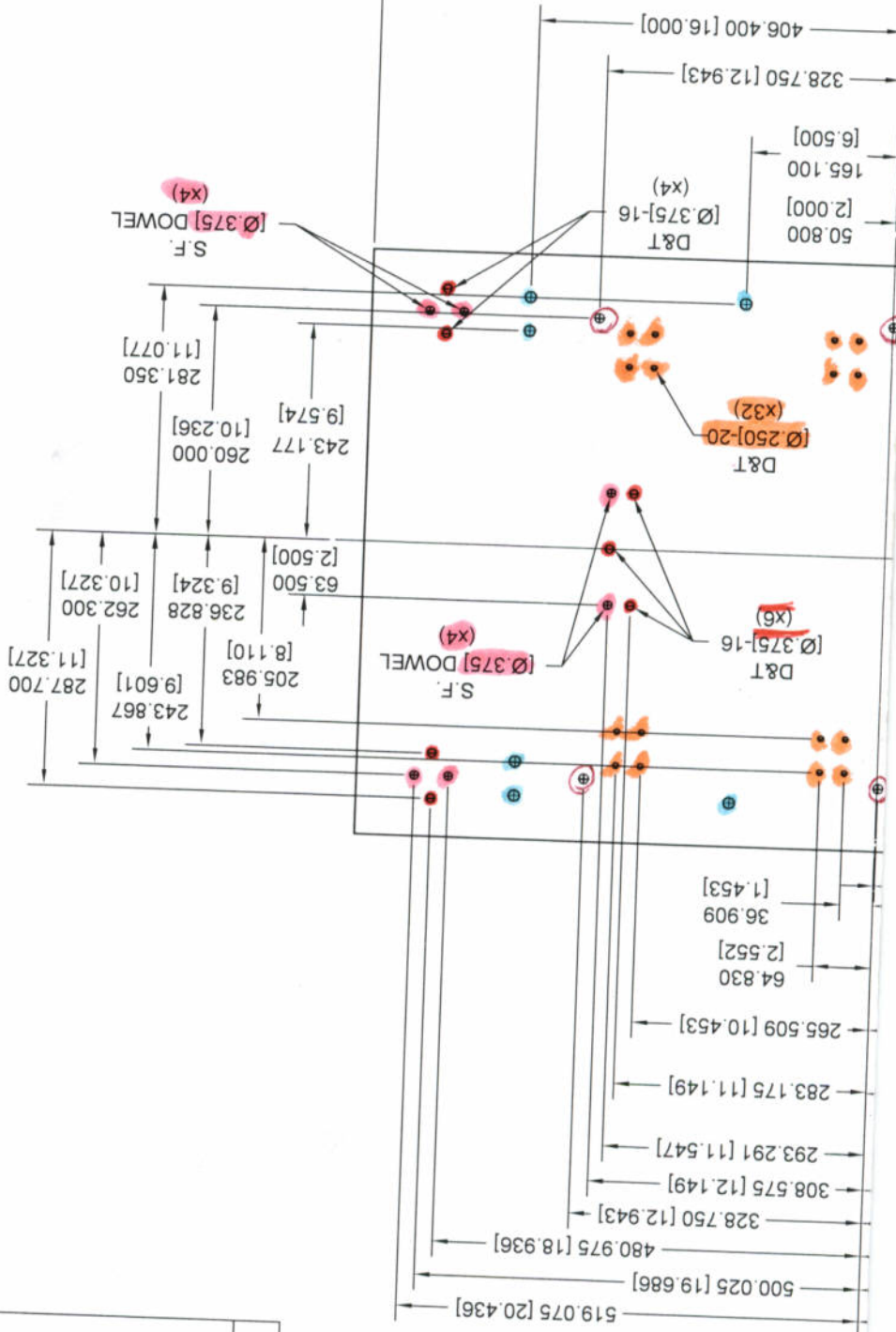
DRAWN BY: PERRITT		REVISIONS	
APPROVED		DATE	
HEAT TREAT		DATE	
FINISH SPEC		DATE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TITLE	
TOLERANCES ON:		CHASSIS FIXTURE	
DECIMALS		DWG NO. TM0038P001-FIX-7	
XXX ± .005		REV	
XX ± .01		SCALE	
X ± .1		NTS	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		DATE 10-5-06	
USED ON MODEL		SHEET 3 of 4	
VOIR NOTA PL.0			
1018 FLAT BAR 3 x 3/8 x 6-1/4 LONG			
1018 FLAT BAR 3-1/2 x 3/8 x 6-1/4 LONG			
1018 FLAT BAR 2-1/2 x 3/8 x 6-1/4 LONG			
Ø3/8 x 3/4 DOWEL PINS			
PART #	QTY		
-FIX-7A	1		
-FIX-7B	1		
-FIX-7C	1		
-FIX-7D	2		

RED BARN MACHINE



DRAWN BY: PERITT		CHECKED:		HEAT TREAT:		FINISH SPEC:		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:		UNLESS OTHERWISE SPECIFIED DECIMALS:		FRACTIONS ± 1/32 ANGLES ± 5°		1. BREAK ALL SHARP EDGES 0.15 X 45° PR 015 R		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
TITLE: RED BARN MACHINE		DWG NO.:		SCALE: NTS		DATE: 1-28-06		SHEET: 1 of 1		REV.:		PART #		REV.:			

1168.400 [46.000]



REV	DESCRIPTION	DATE	APPROVED

CUSTOMER NAME: <u>RED BARN</u>		<u>URBOWECA</u>		OPR# <u>1</u>	
PART NAME: <u>Foot</u>		<u>TM0038PD12</u>		PROG # <u>05206</u>	
MATERIAL INFORMATION: <u>RND 1.625" DEKOR</u>					
TOOL #	MATERIAL SIZE & DESCRIPTION	TURRET LOC	JAW STYLE	CHUCK PRESSURE	
1	FACE/TURN	#2	1 5/8 collet	200 PSI	
2	Bore	#7			
3	Cut-off	#11			
4					
5					
6				/	
7					
8					
9					
10					
11					
12					
SET UP NOTE: <u>Z0, Front of material - .020" (material sits @ 1.379" from collet.)</u>					
BAR FEED INFO: <u>infeed = .250, Feed Per Stroke = 1.129</u>					